Work Orde		332		*948	3.32*						Page 1
Revision ID:	D3066-1 Spacer	enter de la companya	:	Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Start Stop	14	S1* S2*
Start Date: Required Date: Reference:	1/29/13 1/29/13	<b>Start Qty:</b> 40.00 <b>Req'd Qty:</b> 40.00	*40* *40*		Cust Item I	D:					
Approvals:	Process Plan	n:	Date: 18-61-3	Tooling: SPC (Y/N):		ite:		R	un Start Stop	1/	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3066	Rev	В									
*100*		FLOW WATER JET		0.00				(T)	1	R	3-1-07
Waterjet FLOW CNC Waterje	`	Memo I-Cut as per Dwg Rev:_ Prog Rev:_ 2-Deburr if	Dog D3066 necessary	0.00							
110 *440*		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				(m			3-1-97
*110* QC Quality Control		Мето		0.00				(3)			x > 1 0 /

120

QC8- Inspect parts - second check

0.00

\*120\*

Quality Control

Memo

0.00

(5) 13·01-9× (6)

												DQA:	Date	: .
NCR:	⁄es	/ No					WORK ORDER NON-C	O	VFOR	MANCE / UP	DATE	•		
						_						QA Closed:	Date	:
Nork Ord	er:						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part I	•						Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	۱o. ِ						Work Order Update			Large Fab	Composite	J	Supplier	
Root					Desc	•	tion of work order update	1	nitial		tion	Sign &		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup ther rocess upplier raining napproved														
							F	AUL	T CATE	GORY		· I	<u> </u>	·
Landi	ng G	Gear					General			. "				
		Bending Centre No Cracks Crushed/0		ntric to (	o/s		Bend BOM/Route Broken/Damaged Burrs		Instruct	ori Incomplete ions Incomplete/I	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi	ct	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
		Cuffs Heat Trea	ıt		}	-	Contamination  Countersink		Mainte Mislabe			Part Moved Positioned V	Vrong	•
		Inspection		Tube		-	Cut Too Short	$\vdash$	Misread			Power Loss/		Other
		Ripples in			<b>-</b>	-	Drill Holes		Offset		<b>L</b>	J	ĭ L	1
		Torque W		xtrusio	n t	-	Drawing		-	Calibration				· · · ·
• *		Turning S			F	_	Finish		ł	Sequence		· · · · ·		

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

\*94832\*

Page 2

December-20-12 9:22:53 AM

Item ID: Revision ID: Item Name: Start Date: Required Date:	D3066-1 Spacer 1/29/13 1/29/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*	Accept	*N900  Cust Item I  Customer:		\   	* Set	tup Star Stop	ı Vı	S1* S2*
Reference: Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:		Ru	n Star Stoj		R1* R2*
Sequence ID/ Work Center II  130  *130*  HandFinish  Hand Finishing	D	Operation Description Chemical Conversion Coa	at per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID			Accept Qty	Reject Qty	Reject Number H 13	Insp. Stamp
140 <b>*140 QC</b> Quality Control		QQB Inspect Part Finish  Memo		0.00				57	<u></u>		(DAS) 19 13.02.21
*150 *150* Packaging Packaging		Identify as per dwg & Sto  Memo  *** STOCK	nck Location: <u>CA</u>	<i>03</i> 0.00			·	57		A	13.02.21

									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-O	CONFORM	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap	1 1	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor	Engineering Quality
NCR No.	-				Use-as-is Work Order Update	Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Ooc/Data				:							
quip/Tooling		! 									
Operator											
Material											
Setup											
Other											
rocess	]	ľ									
Supplier	7	1									
raining											

Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other Ripples in Bend Drill Holes Offset Torque Waves in Extrusion Out of Calibration Drawing Turning Sequence Out of Sequence Finish Wave/Twist in Tube Folio Outside Dimensions

**FAULT CATEGORY** 

Grain

Hardware

Maintenance

Mislabeled

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Over/Under tolerance

Pressure/Forced

Weld

Temperature/Cure

Wrong Stock Pulled

General

Bend

Burrs

BOM/Route

Contamination

Countersink

Broken/Damaged

Unapproved

**Landing Gear** 

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Centre Not Concentric to O/S

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work	Orde	er ID	94832
* * • • •		~ 11	77025

QC21- Final Inspection - Work Order Release

Memo

160

QC

\*160\*

Quality Control

\*94832\*

Page 3

December-20-12 9:22:53 AM Item ID: D3066-1 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Spacer \*40\* 1/29/13 **Start Qty: 40.00 Start Date: Cust Item ID:** Required Date: 1/29/13 Req'd Qty: 40.00 **Customer:** Reference: Start Run Process Plan: Tooling: **Approvals:** Date: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ **Operation** Set Up/ **Tool ID** Tool # Plan Reject Reject Insp. Accept **Work Center ID** Qty Qty Number Stamp Description Code **Run Hours** 

0.00

0.00

M 13-02-22

												DQA:	Da	ite:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	VFORM	MANCE / UP	DATE					
		•										QA Closed:	Da	ite:	
Work Orde	er.					DISPOSITION				AGAINST D	EF	PARTMENT	/PROCESS		
, work ora	-					Rework	1		Skid-tube	Crosstube	٦		Water Jet	П	Engineering
Part I	Vo.					Scrap	1		Machining	Small Fab	┪	Pro	d. Eng. Coor.	-	Quality
	•					Use-as-is	1	Therm	noforming	Finishing	1	Rec/Stor	e/Packaging	П	Other
NCR I	۷o.					Work Order Update	]		Large Fab	Composite			Supplier		
	-		r	ı							_				
Root					·	otion of work order update		nitial		tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	4	Date	Verification	n	QC Inspector
Doc/Data	Ш														
Equip/Tooling	Ш														
Operator	Ш		İ												
Material	Ш									•					
Setup															
Other	Ш														
Process	Ш														
Supplier	Ш											·			
Training															
Unapproved		· · ·		İ			<u></u>	<b></b>							
							AUL	T CATE	GORY						
Landi		I				General	_	1		_		1			1
	-	Bending				Bend		Grain		_		Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	$\vdash$	Cracks				Broken/Damaged		Inspecti	on Incomplete	L		Part Incorre	ct		Weld
	Ш	Crushed/	Crimped.			Burrs		4	ions Incomplete/	Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	it			Countersink		Mislabe	lec			Positioned V	Vrong		
		Inchartio	n Strin in	Tuba		Cut Too Short		Misroac	ł			Power Loss	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

December-20-12 9:22:53 AM

Work Order ID:

94832

Parent Item:

D3066-1

Parent Item Name:

Spacer

**Start Date: 1/29/13** 

Required Date: 1/29/13

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF IPP Rev:B Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	375.7686	0.0945	3.978948	ر. ر د ر		<u>_</u>
6061-T6 .080 Sheet											1013	21-0	
				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code			$\sim$		
				MAT021		375.768632					(-1)		
				1172	285	0.248632					67		
				1197	766	41.32							
				1200	)96	168.8			-				
				1232	279	. 165.4			<u>: 61</u>	3 374			

NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE										
			Q۵	Closed:							
Work Order:	DISPOSITION		AGAINST DEPAR	RTMENT/PRO							
	Rework	Skid-tube	Crosstube	Wa							
Part No.	Scrap	Machining	Small Fab	Prod. Eng							

Work Order:					DISPOSITION	AGAINST DEPARTMENT/PROCESS						
Part N	lo				Rework Scrap Use-as-is Work Order Update	The	Skid-tube  Machining  rmoforming  Large Fab	Crosstube Small Fab Finishing Composite	<b>⊣</b>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update	Initial	А	ction	Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Chief Er	ng Des	cription	Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling		į										
Operator											·	
Material												
Setup						İ					ŀ	
Other												
Process												
Supplier												
Training												
Unapproved												
					F.	AULT CA	TEGORY					
Landir	ng Gear				General				_	_		
	Bending				Bend	Grai	n		Ovalized		Pressure/Forced	
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct _	Weld	
	Crushed/	Crimped.			Burrs	Instr	uctions Incomplete	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled	
	Cuffs				Contamination	Mair	ntenance		Part Moved			
	Heat Trea	it			Countersink	Misla	beled		Positioned \	Wrong	_	
	Inspection	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss,	'Surge	Other	
	Ripples in	Bend			Drill Holes	Offse	et	-				
	Torque W	/aves in E	xtrusio	n 🗀	Drawing	Out	of Calibration					
	Turning S	equence			Finish	Out	of Sequence					
	Wave/Tw	ist in Tub	) De		Folio	Outs	ide Dimensions					

DQA:

Date:

Date:

DART AEROSPACE LTD	Work Order:	94832
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005	, 130	2		V 1802	
0.708	+/-0.010		2		V	
0.354	+/0.010	,709 -32E	1		V	
0.354	+/0.010	,355	D		V	
2.250 (Pitch)	+/-0.005	426.6	<b>10</b>		V	
16.450	+/0.010	16.490	2		T ABU	
0.080	+/-0.010	, 078	2		V	
		-				
						**
	<u> </u>		DAS			

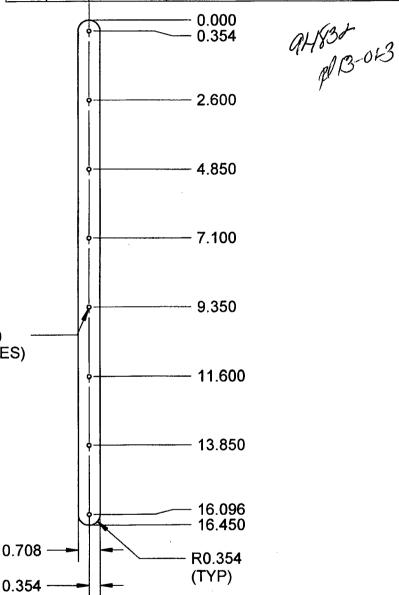
Measured by: B	Audited by:	09	Prototype Approval:	N/A
Date: (3-1-27	Date:	13-0123	Date:	N/A

R	lev	Date	Change	Revised by	Approved
	A	03.09.22	New Issue P/O D3065-041	KJ/RF	
	В	06.06.23	Dwg Rev. changed	KJ/JLM 🚓	411



	DESIGN	4	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
	CHECKE		APPROVED,,,	DRAWING NO.	REV. B	
		PH	The	D3066	SHEET 1 OF 1	
	06.05.29		25.00	SPACER	SCALE	
			J5.29		1:3	
	Α	02	.09.11	NEW ISSUE		
	В	06	.05.29	ADD 6061-T6 MATERIAL		

RELEASED de de za



**D3066-1 SPACER** 

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC. M5052H32S.080)

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

 $\emptyset$  0.128 (#30) (TYP 8 PLACES)

3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 6) ALL DIMENSIONS ARE IN INCHES

0.708

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